

Date: Thursday, 02/04/2009 11:22:51 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB/ GUSSET ASSY
Job Number : 46810	
Estimate Number : 13651	
P.O. Number :	Part Number : D3826041
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D3826 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 46723	Material :
Written By :	Due Date : 08/04/2009 Qty: 4 Um: PD Each
Checked & Approved By : <u>JUD 09-04-02</u>	
Comment : Est Rev:A 08-12-01 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22351	Basket Rib
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Basket Rib

batch: B46771

PD 09-04-06

2.0	D2325	Support Gusset (350 Basket)
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Support Gusset (350 Basket)

batch: B43289 → 3 B46770 → 5

PD 09-04-06

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- use DT9434 to assemble D2325 support gusset together

2- locate D2325 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: M108160

PD 09-04-06 (4)

4.0	QC9	VISUAL WELDING INSPECTION
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(4)

Comment: VISUAL WELDING INSPECTION

PL 09-04-07

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



09-04-07 (4)

Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RIB/ GUSSET ASSY

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Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Bankot CELL*

(4x)

SL 09/04/07

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

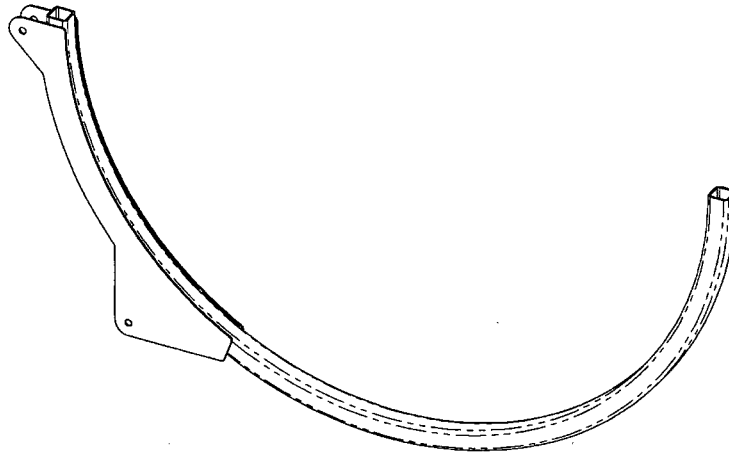
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSEMBLY
2	1	D2235-1	RIB
3	2	D2325	SUPPORT GUSSET



D3826-041 RIB/GUSSET ASSY

RELEASED
08/11/18 NW

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40810

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 2.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3826	REV. A
TITLE RIB/GUSSET ASSY	SHEET 1 OF 2
SCALE NTS	
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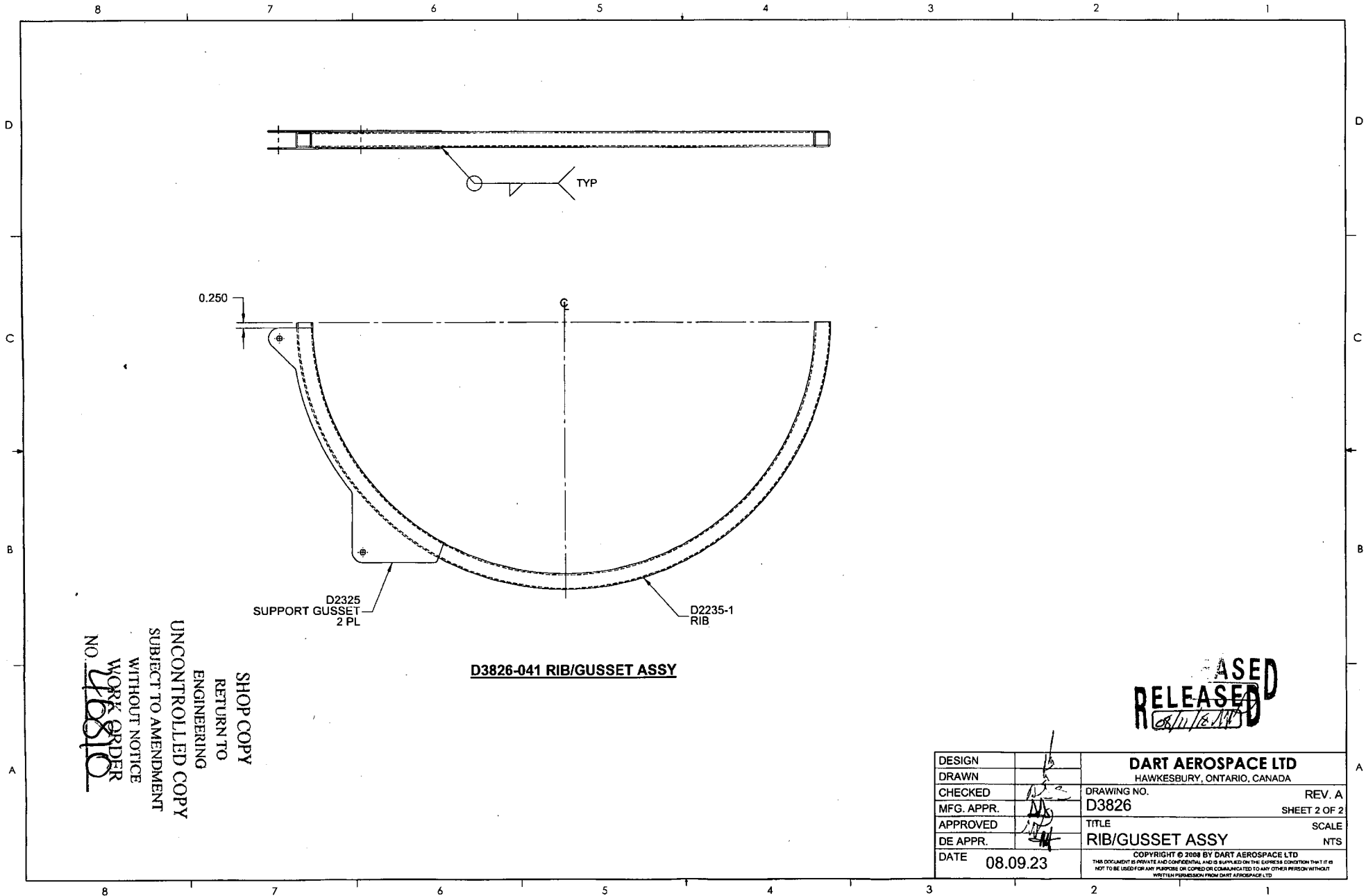
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NOTE: Date & initial all entries



D3826-041 RIB/GUSSET ASSY

RELEASED
08/11/18/19

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DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
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